Date:

Thursday, 28/05/2009 11:51:45 AM

User:

Julie Dawson

Process Sheet

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 48279

Estimate Number

: 11168

First Issue

Written By

Previous Run

P.O. Number

: 28/05/2009

This Issue Prsht Rev.

: NC

: 46689

: 11

: MACHINED PARTS Type

Part Number

Drawing Name

: D22823

: TUBE

Drawing Number

: D2282 REV E

: 04/06/2009

Project Number

: N/A : E

Drawing Revision

Material

Due Date

Qty:

50 Um:

Each

Checked & Approved By

Comment

: Est Rev:A

Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304TR0675W091

304 RD Tube .675 x .091W



Comment: Qty.:

0.2078 f(s)/Unit Total: 10.3898 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch M111456

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA188

2-Deburr

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK





Comment: SECOND CHECK

PACKAGING 1



5.0

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,, <u> </u>			
							-

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDI	ER NON-CONFORMAN	CE (NCR)						
		Description of NC		Corrective Action Section B		Verification	A	Annessal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
				·							

Date:

Thursday, 28/05/2009 11:51:45 AM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 48279

Part Number: D22823

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CH	IANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector	
Part No) :	PAR #: Fault Category:	NCR: Yes	No DO	۸.	Date:		

Part No:	-	PAR #:	Fault Categ	jory:	NCR: Yes N	o DQA :	_ Date: _		
	Res	olution:	Disposition		QA: N/C Clos	a: N/C Closed: Date:			
NCR: WORK DATE STEP Description of NC Section A Initial	WORK ORDE	R NON-CONFORMAN	CE (NCR)	•					
NCR:		Description of NC		Corrective Action Section I	3	Varification			
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approva QC Inspecto	

DART AEROSPACE LTD	Work Order:	4227
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
---	---------------	--	-----------

Drawing	T-1	Actual		Datast	Method of	0
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
2.375	+0.000/-0.020	2.361				
	,					

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 09106103	Date: 09-06-04	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.11.11	New Issue	P/O D350-615-041	KJ/RF	
В	05.04.19	Tolerance changed	-	KJ/JLM , ,	1
С	06.03.15	Dwg Rev update		KJ/JLM OK	

W/O:			WORK ORDER O	HANGES				
DATE	STEP	PROC	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•						
***			***					
Part No	:	PAR #:	_ Fault Category:	NCR: Yes	No DQ	A:	Date: _	

Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:			WORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B		A-1	Verification	A	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						:		

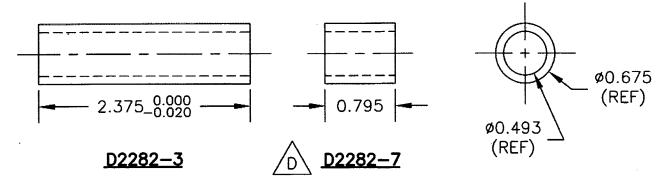
NOTE: Date & initial all entries

Resolution:

DART

	DESIG	BW B	DRAWN BY	DART AEROSPACE L HAWKESBURY, ONTARIO, CANADA	.TD
	CHEC	KED:O	APPROVED	DRAWING NO.	REV. E
		w	1000	D2282 s	HEET 1 OF 2
	DATE		LHOV	TITLE	SCALE
	05.0	06.07		HANDLE TUBES	1:1
	A		94.10.14	NEW ISSUE	
	В		95.03.23	RE-DESIGN	
ı					

DATE			TITLE SCALE
05.0	6.07		HANDLE TUBES 1:1
A		94.10.14	NEW ISSUE
В		95.03.23	RE-DESIGN
С		97.10.20	CORRECTED NUMBERING SCHEME
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
Ε		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP $0.090 \times 45^{\circ}$ 0.95 -CHAMFER 0.158 Ø0.700 R0.350 -Ø0.386 0.125 $0.080 \times 45^{\circ}$ (REF) **CHAMFER** SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY D2282-5 SUBJECT TO AMENDMENT

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750) (1)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

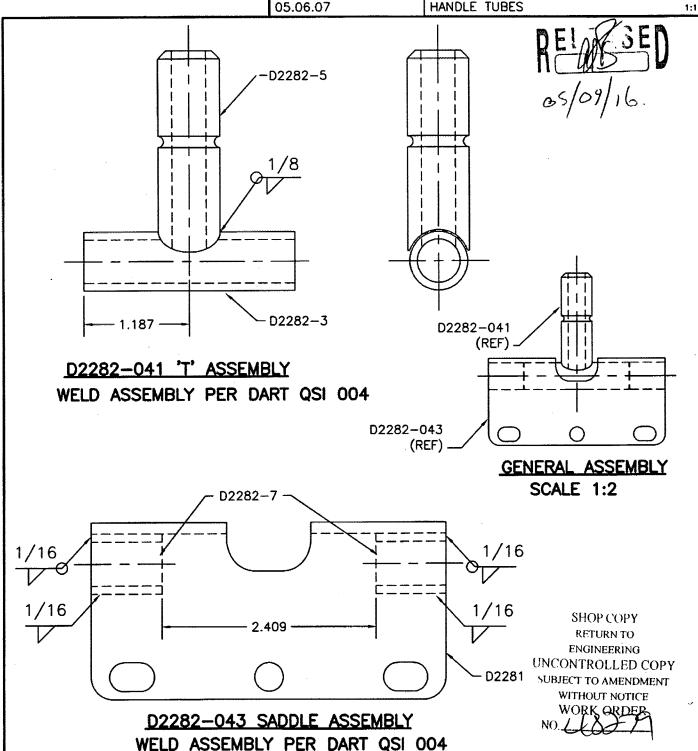
W/O:		WORK ORDER CHANGES								
DATE STEP		PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			

Part No:	- N	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	OTED	STEP Description of NC	Corrective Action Section B				Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	QC Inspector		
							·			



DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED	DRAWING NO.	REV. E
l u	11116	D2282	SHEET 2 OF 2
DATE	114	TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



Copyright @ 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace	Ltd:
----------------	------

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector		
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:			

Resolution:		esolution:	Disposition	Closed: Date:				
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCR)			····
		STED Description of NC	Corrective Action Section B		Mawisia asi an			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
<u>, </u>								